

Lundi

Dart Aerospace Ltd.

Date: Thursday, 6/8/2006 1:01:37 PM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	LUG BRACKET
<b>Job Number</b> :	27466		
<b>Estimate Number</b> :	10364		
<b>P.O. Number</b> :	N/A	<b>Part Number</b> :	D3046041
<b>This Issue</b> :	6/8/2006	<b>Drawing Number</b> :	D3046 REV. A
<b>Prsht Rev.</b> :	NC	<b>Project Number</b> :	N/A
<b>First Issue</b> :	N/A	<b>Drawing Revision</b> :	A
<b>Previous Run</b> :	27188	<b>Material</b> :	N/A
<b>Written By</b> :	See comment below	<b>Due Date</b> :	6/15/2006
<b>Checked &amp; Approved By</b> :		<b>Qty:</b>	6
<b>Comment</b> :	Est: A 01.08.27 New issue SM/EC	<b>Um:</b>	Each

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	D30461	Lug Bracket
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

LUG BRACKET

Qty	Part Number	Description	Batch
1	D3046-1	Lug Bracket	B 27196

2.0	D30463	Lug Bracket
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

LUG BRACKET

Pick:

Qty	Part Number	Description	Batch
1	D3046-3 ( Bell P/N: 206-052-106-1)	Lug Bracket	N/A
		Return Authorization #	R 487
		Bell original batch#	4x A6345 1x A6302 1x D2452

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

- 1- Tranfer drill holes from D3046-3 into D3046-1 as per Dwg D3046
- 2- Counter sink inside holes of D3046-1 as per Dwg D3046
- 3- Deburr

SAD 06/06/09

SB 06/06/09

4.0	MS20426AD57	Rivet
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**Comment:** Qty.: 10.0000 Each(s)/Unit Total: 60.0000 Each(s)

Rivet

Qty	Part Number	Description	Batch
10	MS20426AD5-7	Rivet	M 387C

SB 06/06/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: SD Date: 06/06/07  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 6/8/2006 1:01:37 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG BRACKET

Job Number: 27466

Part Number: D3046041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1  
Assemble as per Dwg D3046

SB 06/06/09 (6)

6.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

06-06-09 (6)

7.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING  
Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

DL 06/06/09 (6)

8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT

06/06/09 (6) SB 06/06/09 (6)

9.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1  
Identify and Steek  
Location: \_\_\_\_\_

N/A sl 06/06/09

10.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL  
Inspection Level 21

06/06/09

Job Completion



N 06/06/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

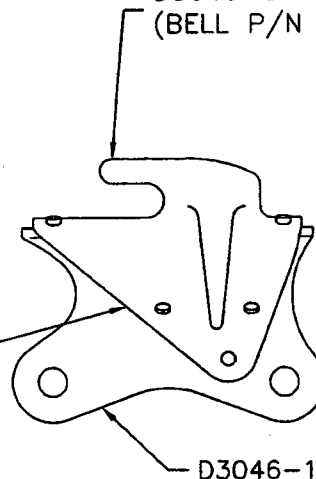
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
		DRAWING NO.	REV. A	
CHECKED	APPROVED	D3046	SHEET 1 OF 2	
DATE		TITLE	SCALE	
01.08.23		LUG BRACKET	1:2	
A	01.08.23	NEW ISSUE		

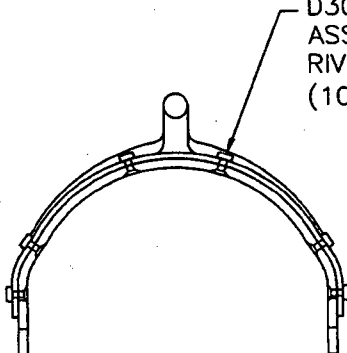
D3046-3  
(BELL P/N 206-052-106-1)



D3046-1

CENTER D3046-3  
ON D3046-1

TRANSFER DRILL  $\varnothing 0.156$  HOLES  
FROM D3046-3 TO D3046-1.  
C'SINK  $\varnothing 0.286 \times 100'$   
D3046-1 INSIDE BORE.  
ASSEMBLE USING MS20426AD5-7  
RIVETS.  
(10 PLACES)



D3046-041 LUG BRACKET ASSEMBLY

NOTES:

- 1) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3.  
POWDER COAT BOTH PARTS SEPARATELY BEFORE ASSEMBLY.  
RE-POWDER AFTER ASSEMBLY.
- 2) REMOVE ALL PAINT/SEALANT FROM D3046-3 BEFORE POWDER COATING.

UNDER REVIEW

06.06.02

CHANGING TO METRIC  
DESIGN

RELEASED  
01.08.23

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

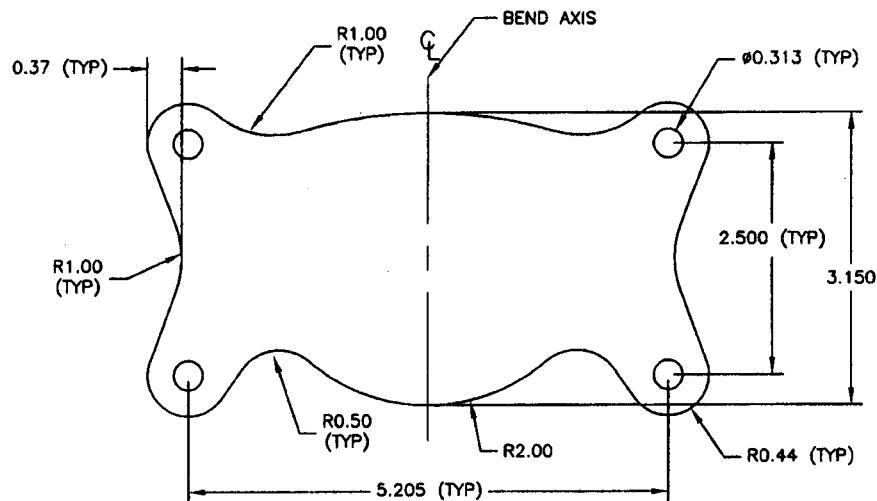
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

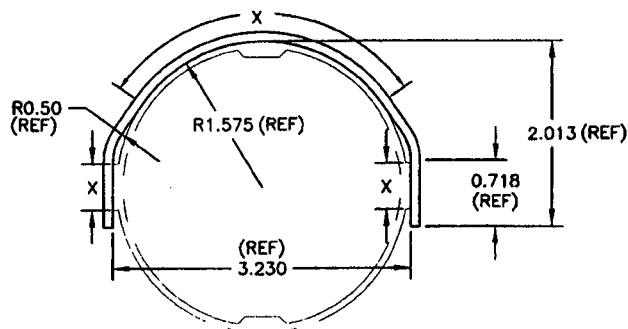
NOTE: Date & initial all entries

**DART**

DESIGN <i>[Signature]</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3046	REV. A SHEET 2 OF 2
DATE 01.08.23		TITLE LUG BRACKET	SCALE 1:2



D3046-11 FLAT PATTERN  
SYMMETRICAL ABOUT CENTRE-LINES (C)



D3046-1  
(MAKE FROM D3046-11)

D3046-1 SHOULD BE BENT SO THAT IT IS WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2600-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

#### GENERAL NOTES

MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL 0.100 THICK (12 GAUGE)  
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi  
MIN. YIELD TENSILE STRENGTH = 28 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE IN INCHES

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UNDER REVIEW

06.06.27